

Date: Monday, 1/7/2008 11:28:37 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STUD
Job Number : 36593	
Estimate Number : 11859	
P.O. Number :	Part Number : D2374
This Issue : 1/7/2008 S.O. No. :	Drawing Number : D2374 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 34345	Material :
Written By :	Due Date : 1/25/2008 Qty: 40 Um: Each
Checked & Approved By : <u>JA 08.01.07</u>	
Comment : Est. D 03.04.04 Reformat; Made on Cobra KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELINR1000	Delrin Round Bar 1"
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Comment: Qty.: 0.1335 f(s)/Unit Total : 5.3382 f(s)

Delrin Round Bar 1"

Material: Black Acetal (Delrin) 1.00" Ø Rod (M-DELRIN-R1.000)

Batch: M 103164

J.F. 08/01/14 (48)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Turn blank as per Folio FA156 and Dwg D2374

Deburr as required

J.F. 08/01/14 (48)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/01/14 (48)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 08/01/17 (48)

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA156 and Dwg D2374

JA 080117 48

6.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JA 080117 48

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STUD

Job Number: 36593

Part Number: D2374

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr as required

~~AS~~ 080117 48

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8F 08/01/12/48

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST30

AS 08/01/18 X48

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08-01-21

Job Completion



2008/1/21

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

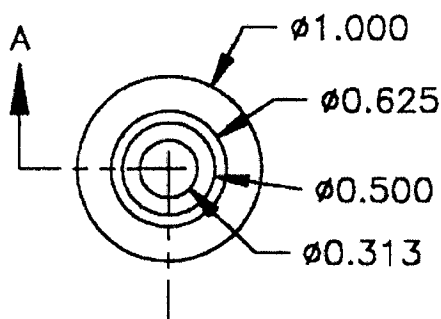
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

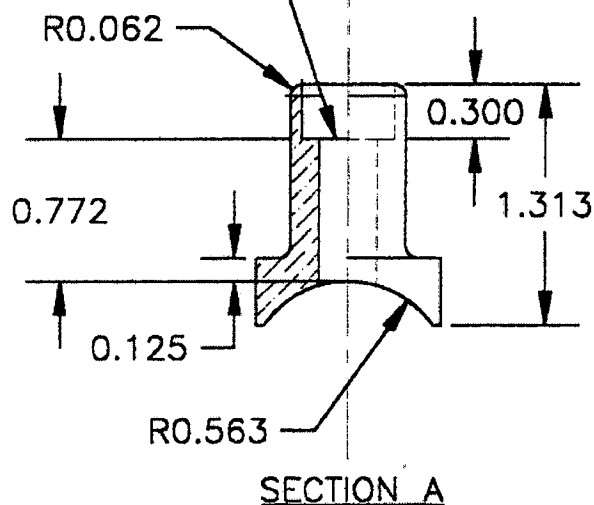
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. A
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	D2374	SHEET 1 OF 1
DATE	TITLE	SCALE	
95:02:24	STUD	1:1	



COUNTER BORE
Ø0.500 X 0.300 DEEP
Ø0.313 THROUGH



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36593

MATERIAL: DELRIN BLACK